

I. AFTER FINAL MACHINING HELIUM LEAK TEST: ACCEPTANCE CRITERIA
 10^{-8} MBAR /CC/SEC.

3. ALL DIMENSIONS APPY PRIOR TO PLATING.

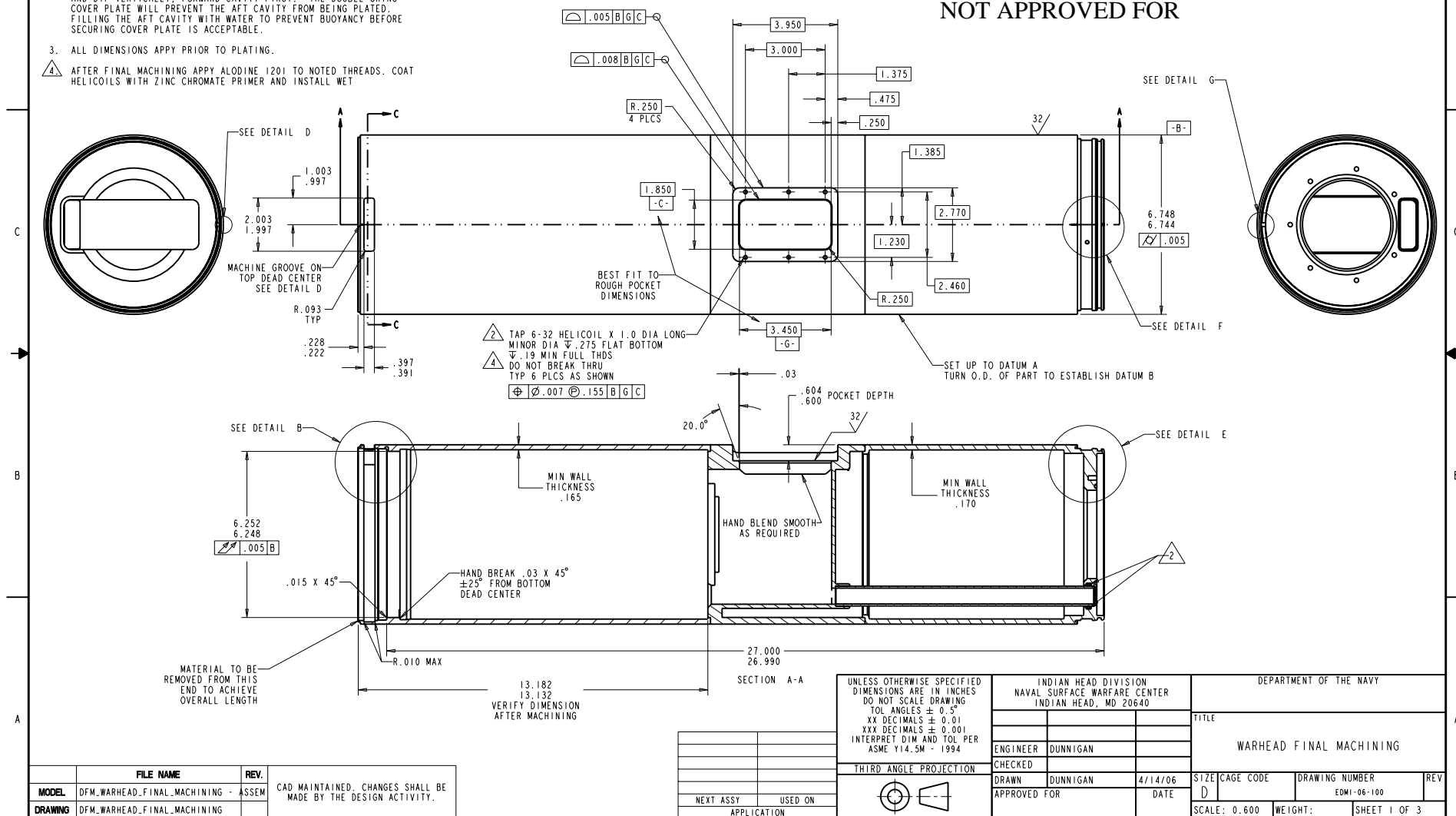
4. AFTER FINAL MACHINING APPLY ALODINE 1201 TO NOTED THREADS. COAT HELICOILS WITH ZINC CHROMATE PRIMER AND INSTALL WET

CLASSIFICATION OF
CHARACTERISTICS
(DOD-STD-2101)

CRITICAL -
MAJOR -
MINOR -

DWG NO		SH	I	REV	I
REVISION HISTORY					
REV	DESCRIPTION			DATE	APPROVED

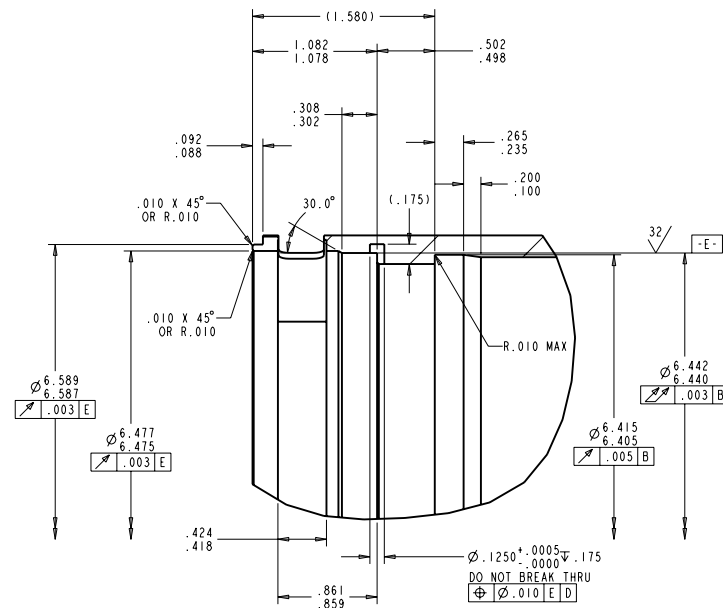
PRELIM
NOT APPROVED FOR



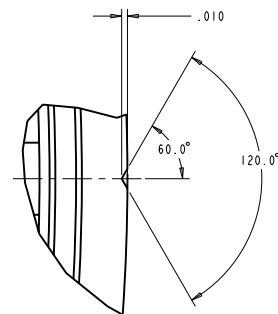
FD, IHD/NSWC D-SIZE FORMAT, REV -, 98/03/03

DWG NO		SH	2	REV	REV	
REV		DESCRIPTION		DATE	APPROVED	

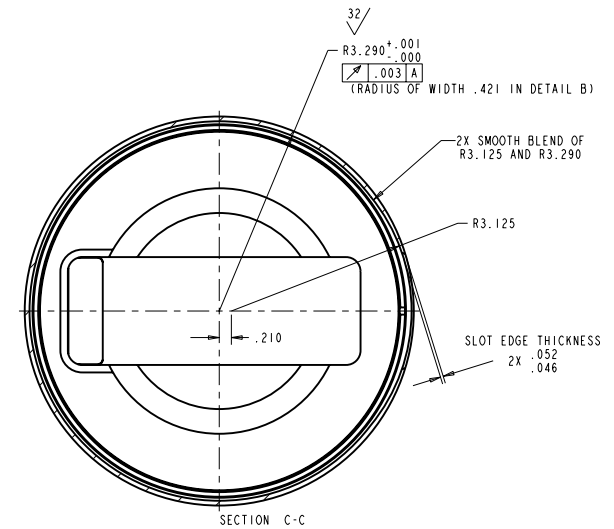
PRELIM
NOT APPROVED FOR



63/ ALL DIMENSIONED SURFACES SHOWN
 DETAIL B
 SCALE 2.000



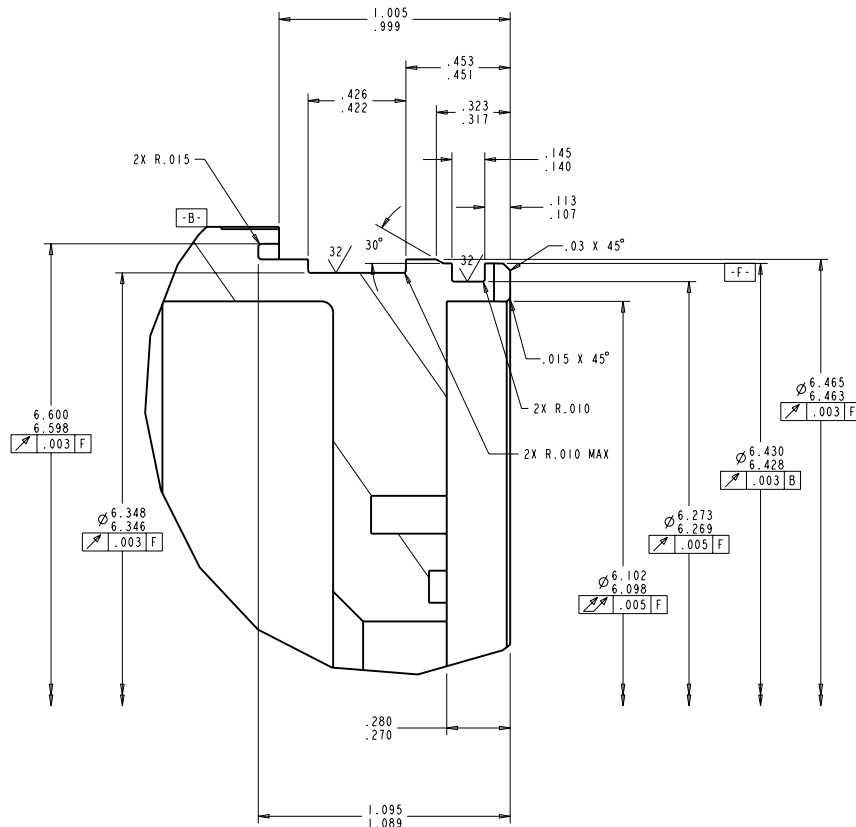
DETAIL D
 SCALE 10.000



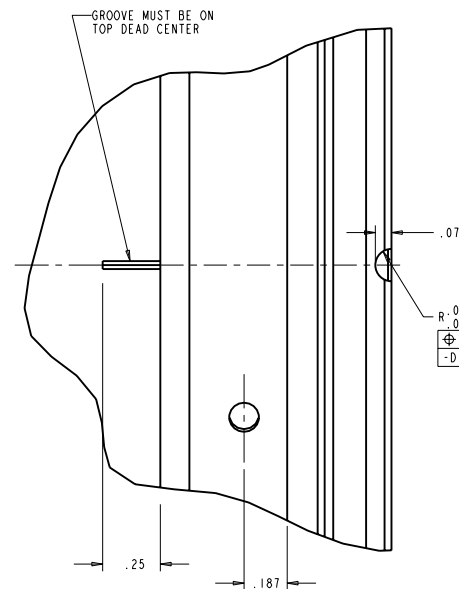
SIZE	CAGE CODE	DRAWING NUMBER	REV
D		EDM1-06-100	
SCALE: 1.000		SHEET 2 OF 3	

DWG NO		SH	3	REV	I	
REVISIONS						
REV	DESCRIPTION			DATE	APPROVED	

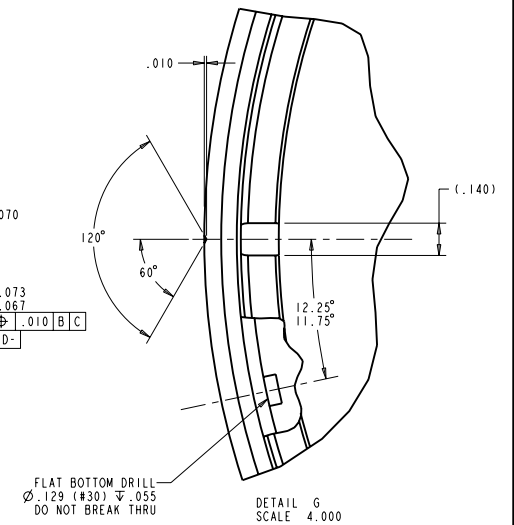
PRELIM
NOT APPROVED FOR



DETAIL E
SCALE 4.000



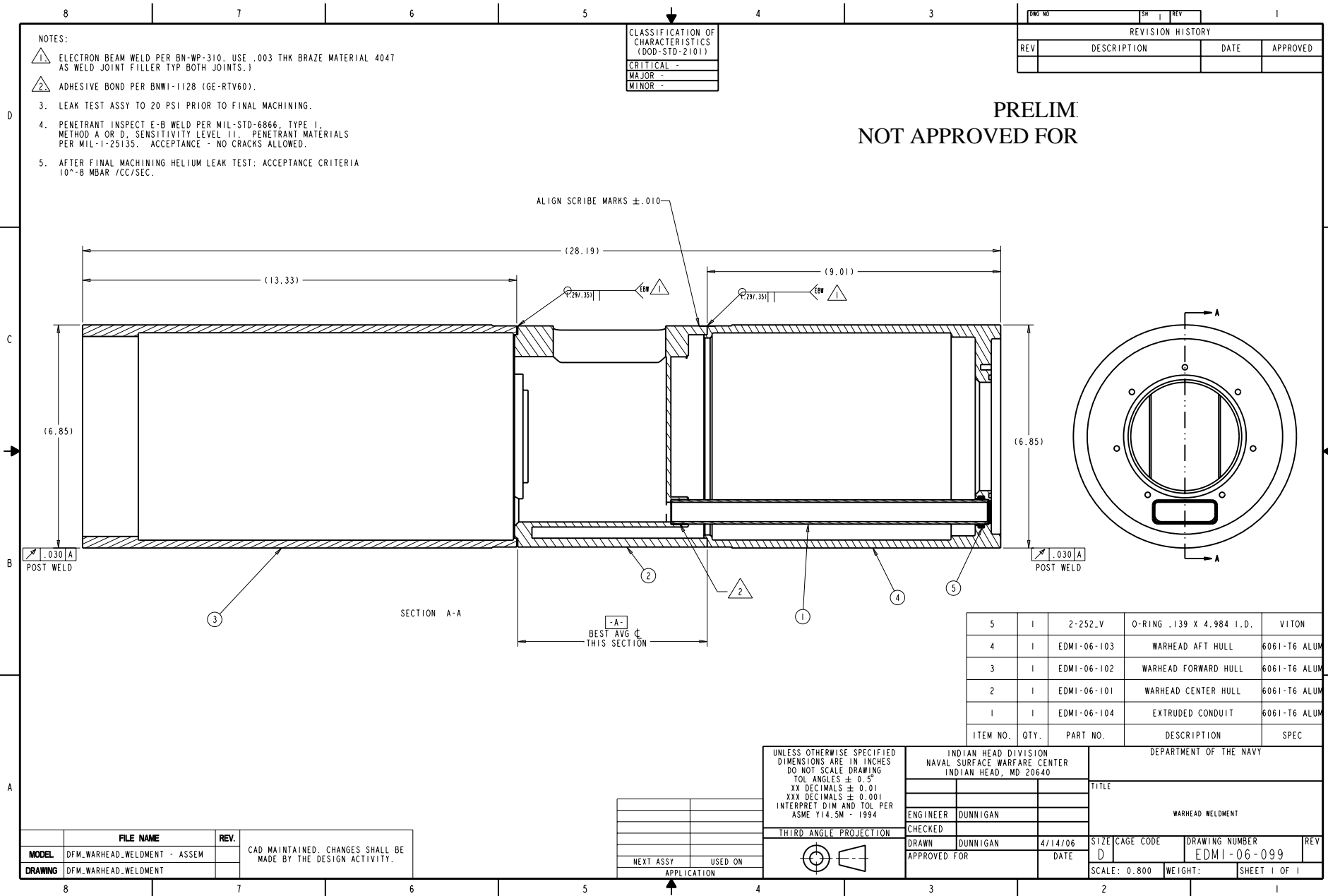
DETAIL F
SCALE 4.000



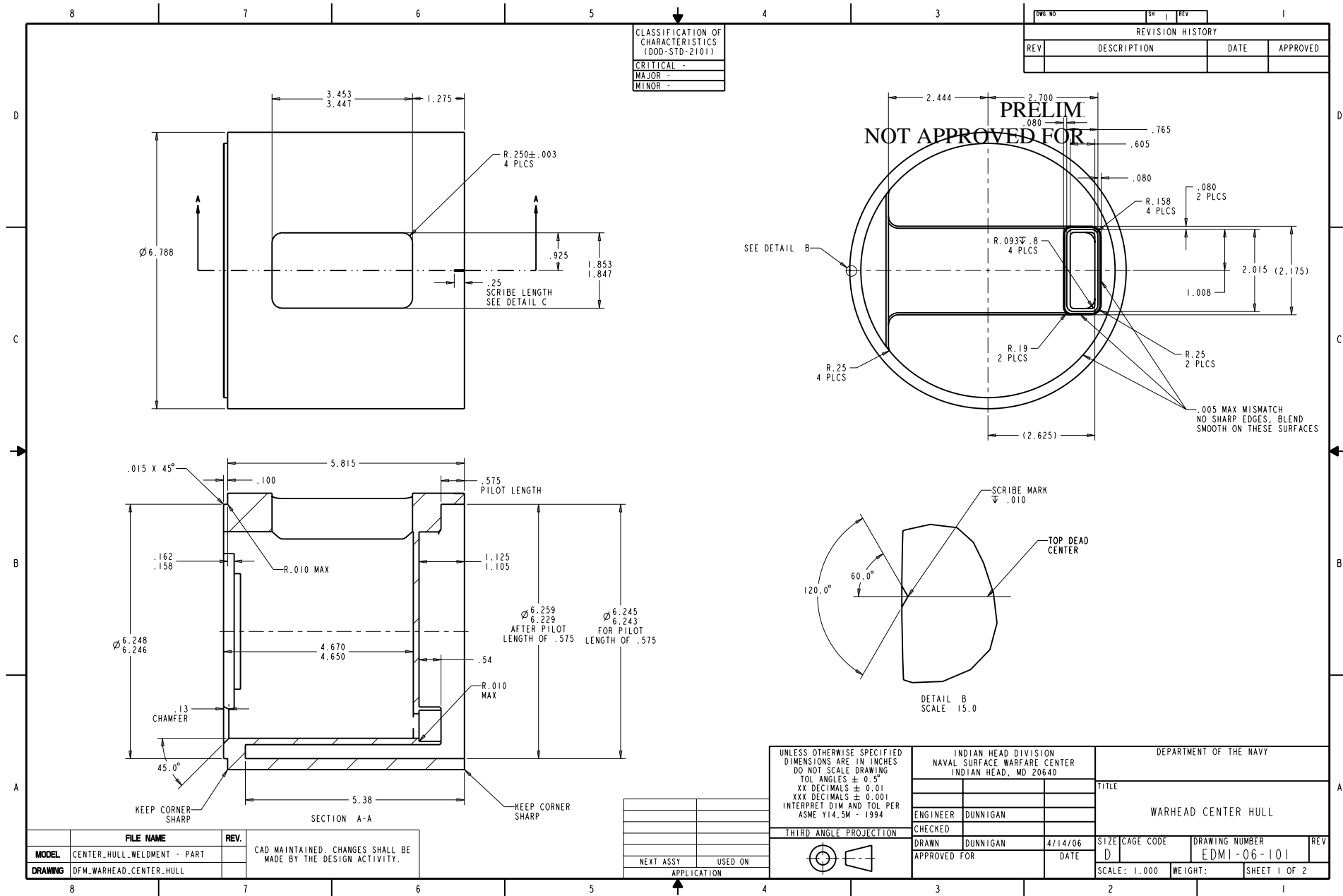
DETAIL G
SCALE 4.000

SIZE	CAGE CODE	DRAWING NUMBER	REV
D		EDMI-06-100	
SCALE: 1.000		SHEET 3 OF 3	

IND. INDIAN HEAD DIVISION - 98/03/03

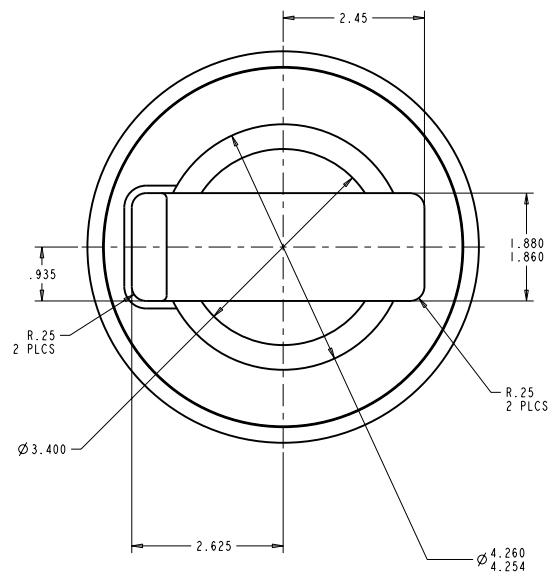


MD: IND/NAVC D-SIZE FORMAT, REV - 98/03/03

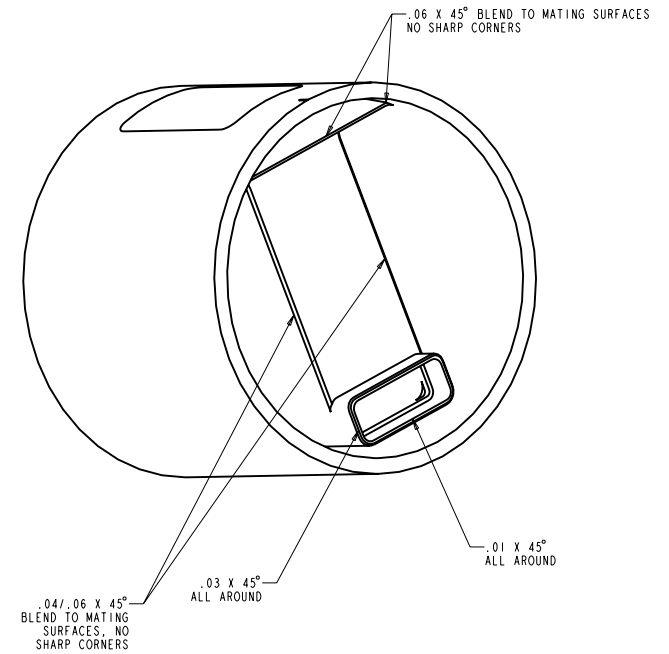
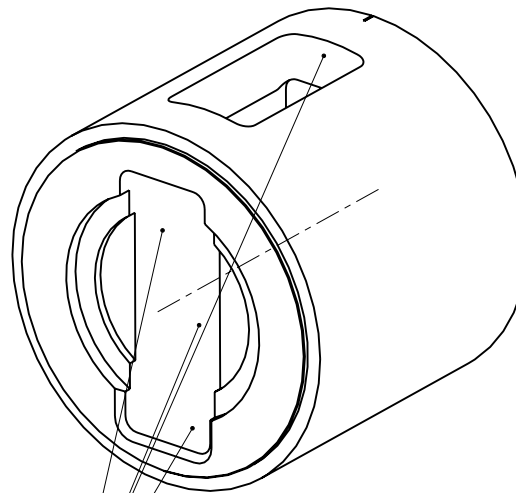


DWG NO	SH 2	REV 1	I
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PRELIM
NOT APPROVED FOR

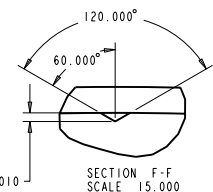
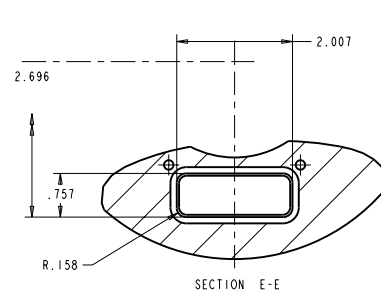
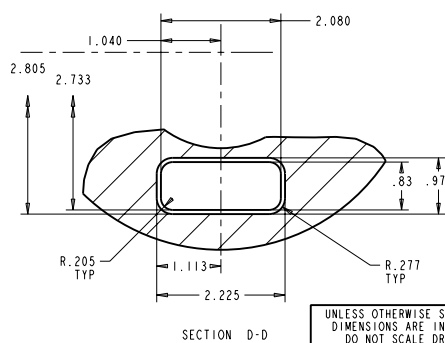
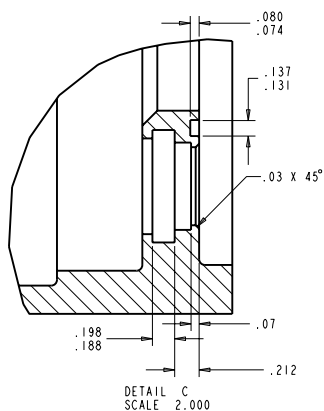
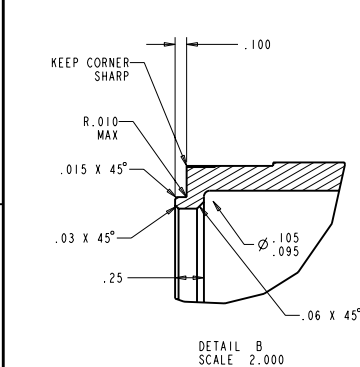
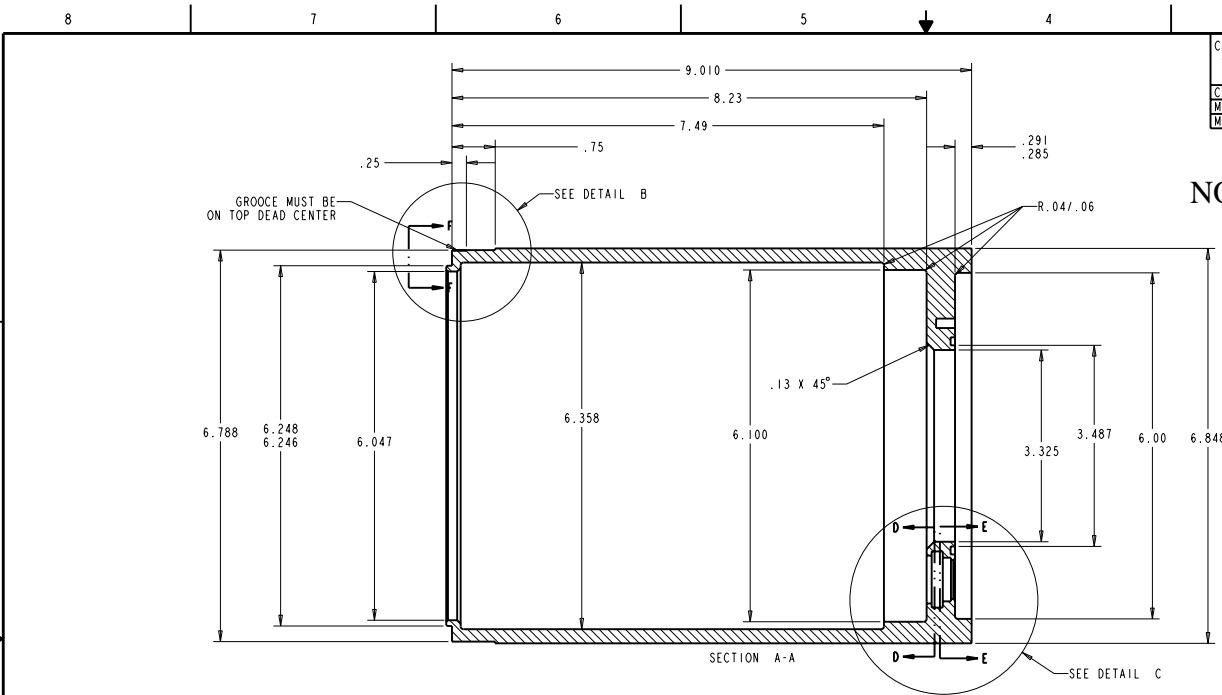


.005 MISMATCH ALLOWED
ON TOP TO SIDE MACHINING
TRANSITION BOTH SIDES OF
INTERNAL CAVITY
NO SHARP EDGE



SIZE	CAGE CODE	DRAWING NUMBER	REV
D			
SCALE: 1.000		SHEET 2 OF 2	

MDI: INDIAN D-SIZE FORMAT, REV. 98/03/03



CLASSIFICATION OF CHARACTERISTICS (DOD-STD-2101)	
CRITICAL	-
MAJOR	-
MINOR	-

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

PRELIM
NOT APPROVED FOR

8-32 UNC - 2B ∇ .328
MINOR ∇ AS REQ'D
DO NOT BREAK THRU
TYP 7 PLCS AS SHOWN
ON A ∇ 4.250 B.C.

FILE NAME	REV.
AFT_HULL_WELDMENT - PART	
DFM_WARHEAD_AFT_HULL	

CAD MAINTAINED. CHANGES SHALL BE MADE BY THE DESIGN ACTIVITY.

APPLICATION	
NEXT ASSY	USED ON

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
DO NOT SCALE DRAWING
TOL ANGLES \pm 0.5°
XX DECIMALS \pm 0.01
XXX DECIMALS \pm 0.001
INTERPRET DIM AND TOL PER
ASME Y14.5M - 1994

THIRD ANGLE PROJECTION



INDIAN HEAD DIVISION NAVAL SURFACE WARFARE CENTER INDIAN HEAD, MD 20640		DEPARTMENT OF THE NAVY	
ENGINEER	DUNNIGAN	TITLE	
CHECKED		WARHEAD AFT HULL	
DRAWN	DUNNIGAN	DATE	4/14/06
APPROVED FOR		SIZE	CAGE CODE
		D	EDM1-06-103
		DRAWING NUMBER	REV
			I
		SCALE: 1.000	WEIGHT:
		SHEET 1 OF 1	

